June 28. 2010 12:02:47 PM

Page 1

I tem ID:

D4134-042

Accept

Revision ID:

Item Name:

Wearplate, RH Aft

Start Date:

6/28/10

Start Qty: 2.00

Required Date: 7/15/10

Req'd Qty: 2.00

Cust Item ID:

Customer:

Stop

Reference:

Approvals:

Process Plan:

A

OC:

Date: 10 6-29 Tooling:

Date:

SPC (Y/N):

Date:

Date:

Run Start

Setup Start

Stop

Sequence ID/

Work Center ID

Draw Nbr

Operation Description

Revision Nbr

Set Up/ Run Hours Tool ID

Tool# Plan Code

Qty

Accept Reject Qty

Reject Number Stamp

Insp.

D4134

1.00 

Waterjet 171.OW CNC Waterjet

BOH LOWS

Memo

Dwg Rev

Prog Rev:

QC2- Inspect parts off machine FAI/FAIB

(),()()

0.00

1-Cut D4134-1F as per Dwg D4134

2-Deburr if necessary Ocher 7 M. 10/06/29 32

B.O. 6. 29

Quality Control

Memo

FLOW WATER JET

1310 6 77

Quality Control

QC8- Inspect parts - second check

Memo

(+3)

Dart Ae	rospace Ltd							
W/O:			WO	RK ORDER CHANGES	3			
DATE	STEP	PR	OCEDURE CHAP	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
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Part No	:	PAR #:	Fault Categ	gory:	NCR: Yes	No DQA:	Date: _	
	Resolu	tion:	Disposition	1;	QA: N/C C	losed:	Date: _	
NCR:			WORK ORDE	R NON-CONFORMAN	CE (NCI	R)		
		Description of NC		Corrective Action Section	A-02	Verification	Approval	Approva
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Section C	Chief Eng	QC Inspecto

June 28, 2010 12:02:48 PM

Item ID:

D4134-042

Revision ID: Item Name:

Wearplate, RH All

6/28/10

Start Date: Required Date: 7/15/10

Start Qty: 2.00 Req'd Qty: 2.00

Reference:

Approvals:

QC:

Process Plan:

Date:

Date:

SPC (Y/N):

Set Up/ Run Hours

0.00

Tooling:

Accept

Date: Tool ID

Cust Item ID:

Customer:

Run

Start

Reject

Qty

Stop

Setup Start

Stop

Reject

Number

Sequence ID/ Work Center ID

130

Brake NC

Brake NC

Operation Description

Form as per dwg NC BRAKE

0.00 1- Form using DT\_\_\_\_\_ Die as per Dwg D4134

D+ 9641

Code

Tool # Plan

\$ 1007.13 - accepty

Accept

Qty

140

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Date:

150

Large Fab Large Fab

Weld per dwg A/R Hardcoat S.S. Batch: M1/4705 0.00

Large Fab

Weld hard surface using DT very as per QSI 004 and Dwg D4134

Page 2



Insp. Stamp

#### **Dart Aerospace Ltd** W/O: **WORK ORDER CHANGES** Approval Approval DATE STEP PROCEDURE CHANGE By Date Qty Chief Eng / QC Inspector Prod Mgr Part No: Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_ Resolution: WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B Description of NC Verification Approval Approval STEP DATE Sign & **Action Description** Initial Section A Section C Chief Eng QC Inspector Date Chief Eng Chief Eng

NOTE: Date & ini	E-		i.		

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June 28, 2010 12:02:48 PM

I tem ID:

D4134-042

Revision ID:

Item Name:

Wearplate, RH Aft

Start Date:

6/28/10

Start Oty: 2.00

Required Date: 7/15/10

Reg'd Qty: 2.00

Reference:

Approvals:

Process Plan:

OC:

Date:

Date:

Accept

SPC (Y/N):

Tooling:

Set Up/

Run Hours

21/20/01/

Date:

Cust Item ID:

Customer:

Tool ID

Date:

Tool # Plan

Code

Run

Accept

Oty

Start

Reject

Qty

Sequence ID/ Work Center ID

160

Quality Control

Operation

QC10- Inspect visual per QS1004- ground welds

Description

Memo

QC5- Inspect part completeness to step on W/O

Memo

0.00

OC.

170

Quality Control

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3,5.6) per QS1005 4.3

Memo

MIIZ588 0.00 => MI (0/07/15 / START TIME: 1.000 M FINISH TIME:

0.00

Phr Paraphic 0

Page 3

Stop

Setup Start

Stop

Reject Number

Insp. Stamp

\$ 16.07.14 D

Dart Ae	rospace Lt	td						
W/O:			WC	RK ORDER CHANGE	S			
DATE	STEP	PR	PROCEDURE CHANGE		Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
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Part No	) <b>:</b>	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	Date:	
	Resc	olution:	Disposition: QA: N/C Closed:					
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### Work Order ID 60169 June 28. 2010 12:02:48 PM

Item ID:

D4134-042

Revision ID:

Wearplate, RH Aft

Item Name: Start Date:

6/28/10

OC:

Start Qty: 2.00

Required Date: 7/15/10

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Reg'd Qty: 2.00

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop



Sequence 1D/ Work Center ID

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ Run Hours

0.00

0.00

0.00

Tool ID

Tool# Plan Code

Accept Qty

Reject Qty

Reject Number Insp. Stamp

B 10 07.15 0

Small Fab

Quality Control

Small Fab

1- Bond D4134-3 gasket to inner surface of wearplate using a thin layer of 3M 1300/1300L scotch grip adhesive

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

=7 m/ L 10/07/15

18 10:07. 15 0

Dart Ae	rospace Ltd								
W/O:			WO	RK ORDER CHANGES	3				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Approval Chief Eng / Prod Mgr	ng/ Approvar	
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	Resolut	ion:	Disposition	:	QA: N/C C	osed:		Date: _	
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		Description of NC	1	Corrective Action Section	В	Verific	erification Approval		Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Sect	ion C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

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Page 5

Friday, July 16, 2010 10:01:30 AM Accept Item ID: D4134-042 Setup Start Revision ID: Stop Item Name: Wearplate, RH Aft Start Date: 6/28/2010 Start Qty: 2.00 Cust Item ID: Required Date: 7/15/2010 Req'd Qty: 2.00 Customer: Reference: Run Start Approvals: Process Plan: Date: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Tool ID Tool# Plan Reject Sequence ID/ Operation Set Up/ Accept Work Center ID Qty Qty Description Code Run Hours Identify as per dwg & Stock Location: 0.00 Packaging Packaging 0.00 Memo Packaging

230

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Reject

Insp. Number Stamp

mt 10-7-16

W/O:	rospace Ltd		WO	DE OBDED CHANCE	C				
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sec	tion C	Chief Eng	Approval QC Inspecto
						-			

Picklist Print
June 28, 2010 12:02:46 PM

Work Order ID: 60169

Comments:

304/316 .050 Sheet

Parent Item: D4134-042

Parent Item Name: Wearplate, RH Aft



Start Date: 6/28/10

Start Qty: 2.00

Required Date: 7/15/10 Required Oty: 2,00

Date

Issued

Component Item ID/ Item Name	Replacement Item ID	Mfg Pur
D4134-3		Man
Gasket M304S18GA		Dues

ent	Purch
	Manufactu
	Purchased

IPP Rev:A 10.06.25 new issue DD vcrfiEC

Bin Item	Primary Location	Last Location	Route Seq ID
No			200
No			100

Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty
200	Each	0.0000		2
100	sf	132,8779	1.5825	3.33157

		100
	Durala	A 12

Qty

Issued

Location	Loc Qty	Loc (
MAT20	132,8779	
111743	8.86	
112885	28.0179	
113062	96	
	525	

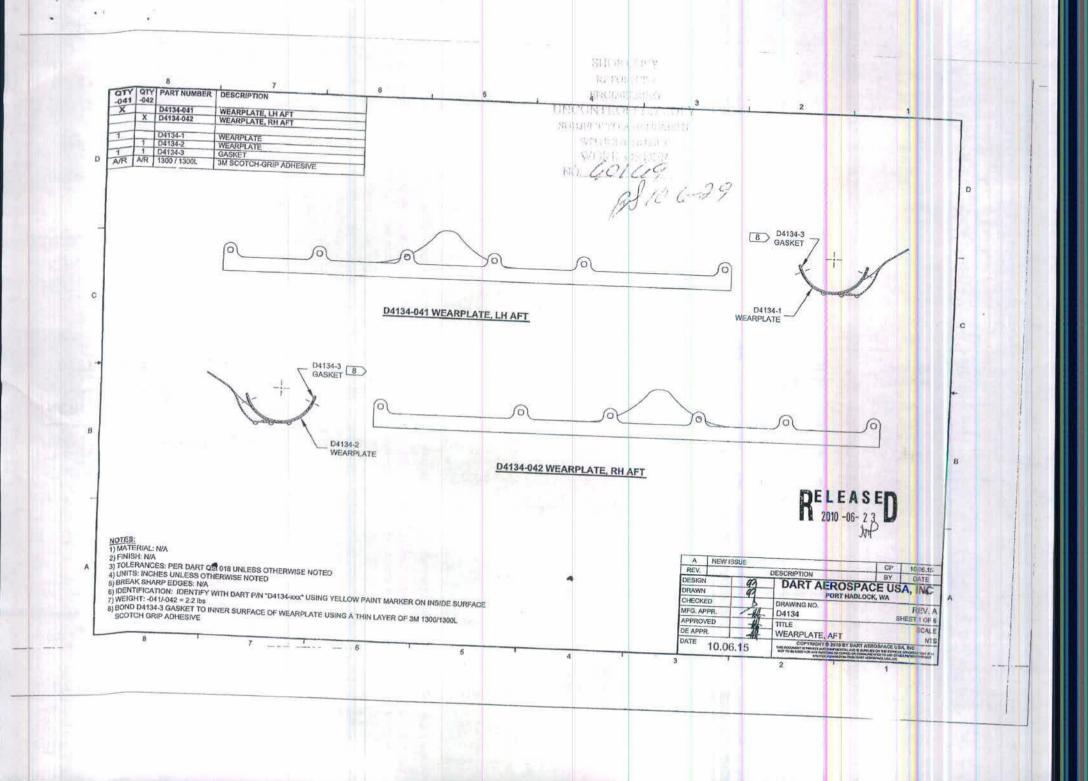
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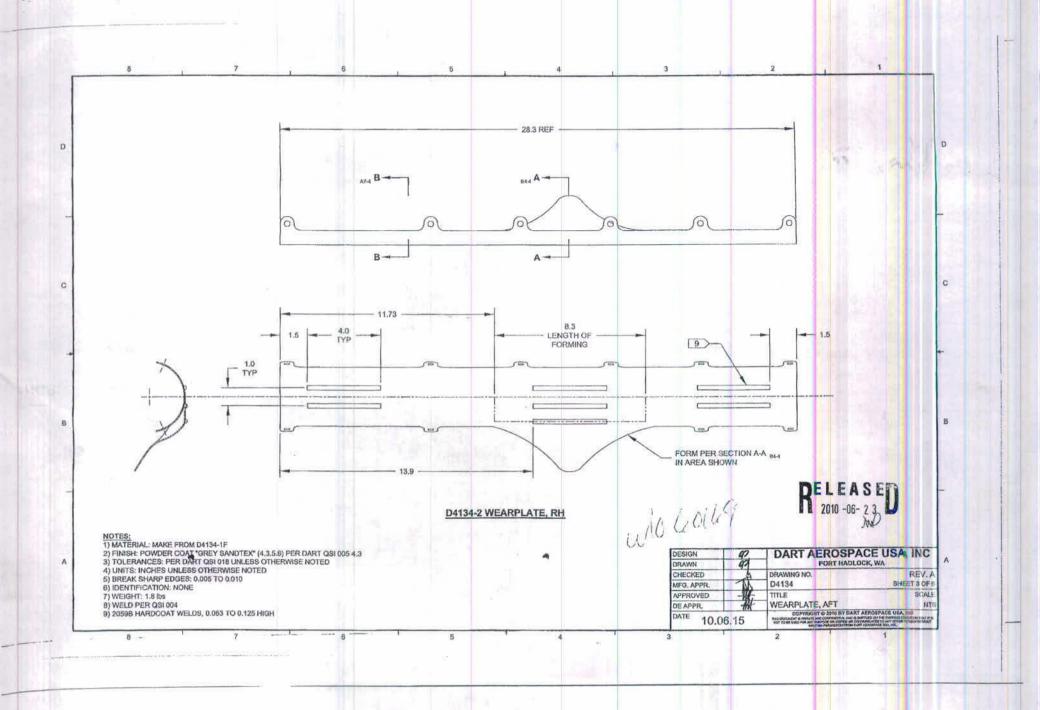
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Page 1

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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		n & ite		ion C	Chief Eng	QC Inspecto



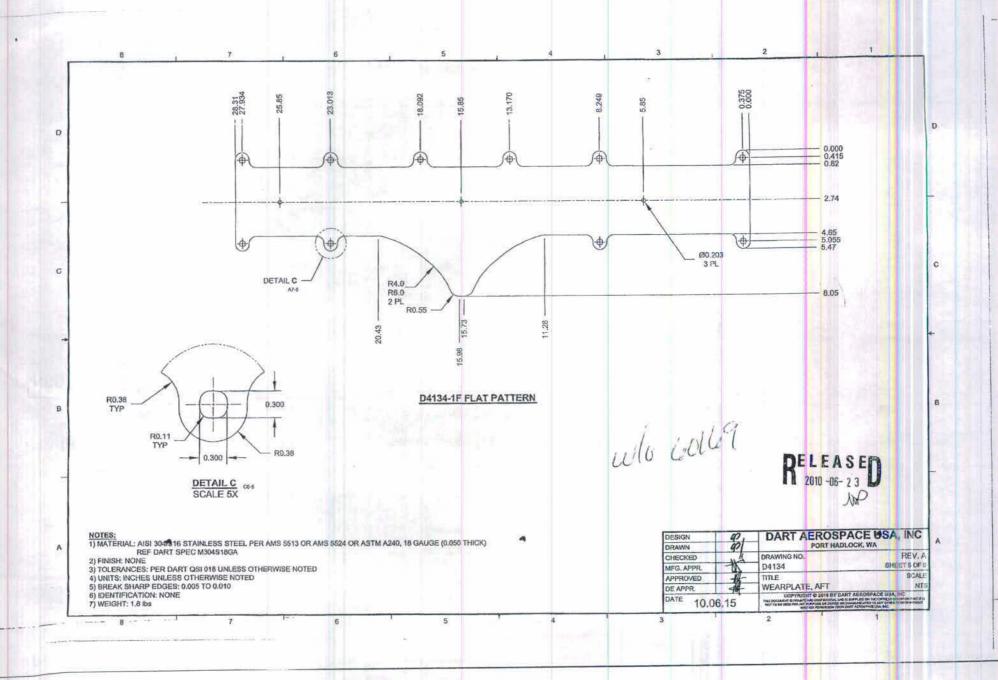
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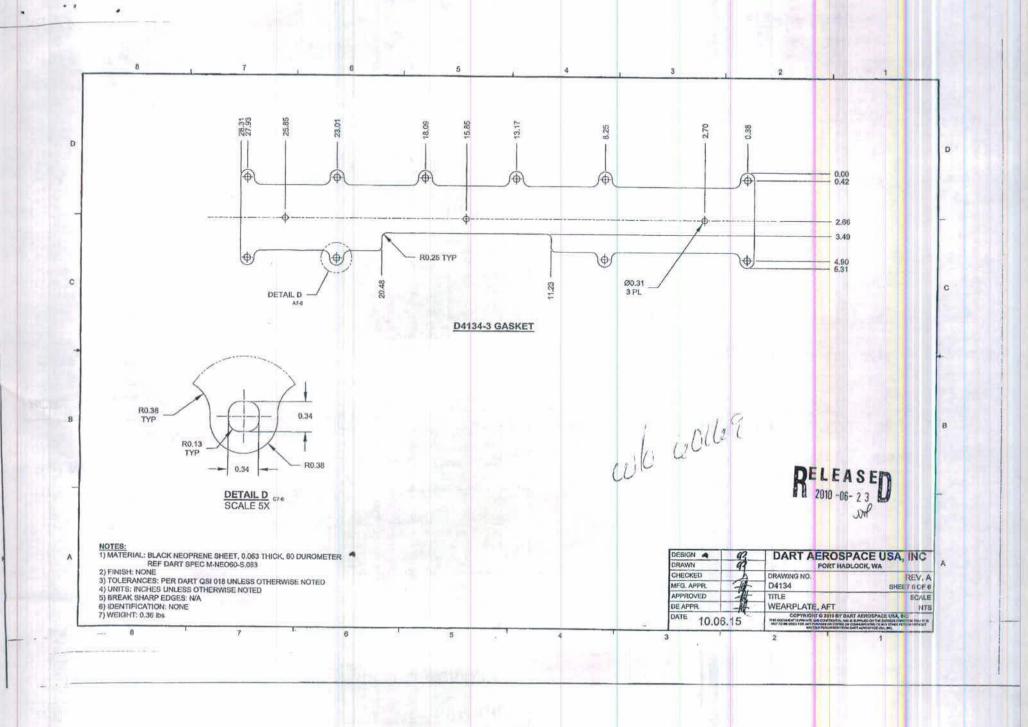
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		tion C	Chief Eng	QC Inspector

NOTE: Date & initial all entries

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Dart Ae	rospace Ltd							
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DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section C	Chief Eng	QC Inspecto



#### **Dart Aerospace Ltd** WORK ORDER CHANGES W/O: Approval Approval STEP DATE PROCEDURE CHANGE By Qty Date Chief Eng / QC Inspector Prod Mgr Part No: PAR #: Fault Category: NCR: Yes No DQA: \_\_\_\_ Date: \_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_ Resolution WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B Description of NC Verification Approval Approval DATE STEP Sign & Initial **Action Description** Section A Section C Chief Eng QC Inspector Date Chief Eng Chief Eng

DART AEROSPACE LTD	Work Order:	66169
Description: WEAR PLATE RH. AFT.	Part Number:	D4134-042
Inspection Dwg: D 4(34-1 Rev: A-		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

Y	First Article	Prototype
Α.	FIRST AFTICLE	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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- 300	4- 100	. 363	2	*		
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23.03	4010	33.68	X			
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Date:	10-6-97	Date: 6/6/136		1737/2012

Rev	Date	Change	Revised by	Approved
Kev	Date	New Issue	KJ/JLM	
A		INCM ISSUE		

### **Dart Aerospace Ltd** WORK ORDER CHANGES W/O: Approval Approval STEP DATE PROCEDURE CHANGE By Qty Date Chief Eng / QC Inspector Prod Mgr Part No: PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_ Date: \_\_\_\_ Disposition: QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_ Resolution WORK ORDER NON-CONFORMANCE (NCR) NCR: Corrective Action Section B Description of NC Verification Approval Approval DATE STEP Sign & Initial **Action Description** Section A Section C Chief Eng QC Inspector Date Chief Eng Chief Eng

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANG		7.1	Qty	Approval Chief Eng /	Approval oc inspector
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			The second				
Part No		PAR #: Fault Category:	NCR: Ye	es No D	QA:	Date:	

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NCR:		ORK ORL	DER NON-CONFORMAN		Verification	Approval Chief Eng	Approval QC Inspector	
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